

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76734

76734

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November 21, 2011 9:25:58 AM

Item ID: D3250-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Back
 Start Date: 11/21/11 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 11/29/11 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg Small Fab Memo	0.00 0.00		SB 11/11/22		(2)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8 11/11/22		(2)			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00						11 - 11 - 23 (2)	

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160									
Powdercoat		0.00							
Powder Coating									
	Memo								
	START TIME: 1:45								
	FINISH TIME: 3:20								
	OVEN TEMPERATURE: 275								
170	QC3- Inspect Part Finish	0.00							
170									
QC		0.00							
Quality Control	Memo								
180	Identify as per dwg & Stock Location: 144	0.00							
180									
Packaging		0.00							
Packaging	Memo								

2X M-11/11/28

2 BR 11-11-28

11/11/28 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

11/11/29 *[Signature]*
mf
 11-11-28

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Picklist Print

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Page 1

Work Order ID: 76734

Parent Item: D3250-1

Parent Item Name: Back

Start Date: 11/21/11

Required Date: 11/29/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP B 04.10.26 D3250-1 no longer made in-house
IPP Rev:C As per Rev C 06-03-07 JLM
HOUSE DD VERF:EC

IPP REV:D 11.11.21 MADE IN

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	33.5000	2.902	6.1094737			
1811-21													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		33.5							
				117392		33.5							
									117392				

2

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DART AEROSPACE LTD		Work Order:	76734
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
19.902	± .010	19.902	>		T 11301	
21.000	± .010	21.000	>		T	
4.78	± .030	4.778	>		V 11365	
2.19	± .010	2.192	>		V	
3.00	± .030	2.998	>		V	
4.00	± .030	3.998	>		V	
3.00	± .030	2.999	>		V	
5.00	± .030	5.000	>		V	
3.94	± .030	3.945	>		V	
3.00	± .030	2.996	>		V	
4.00	± .030	4.00	>		V	
5.34	± .030	5.348	>		V	
5.00	± .030	5.002	>		V	
6.00	± .030	6.001	>		V	
3.34	± .030	3.343	>		V	
6.34	± .030	6.347	>		V	
10.63	± .010	10.61	>		V	

Measured by:	B
Date:	11-11-21

Audited by:	J
Date:	11/11/21

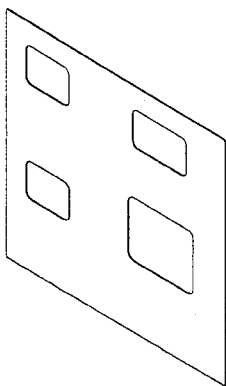
Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



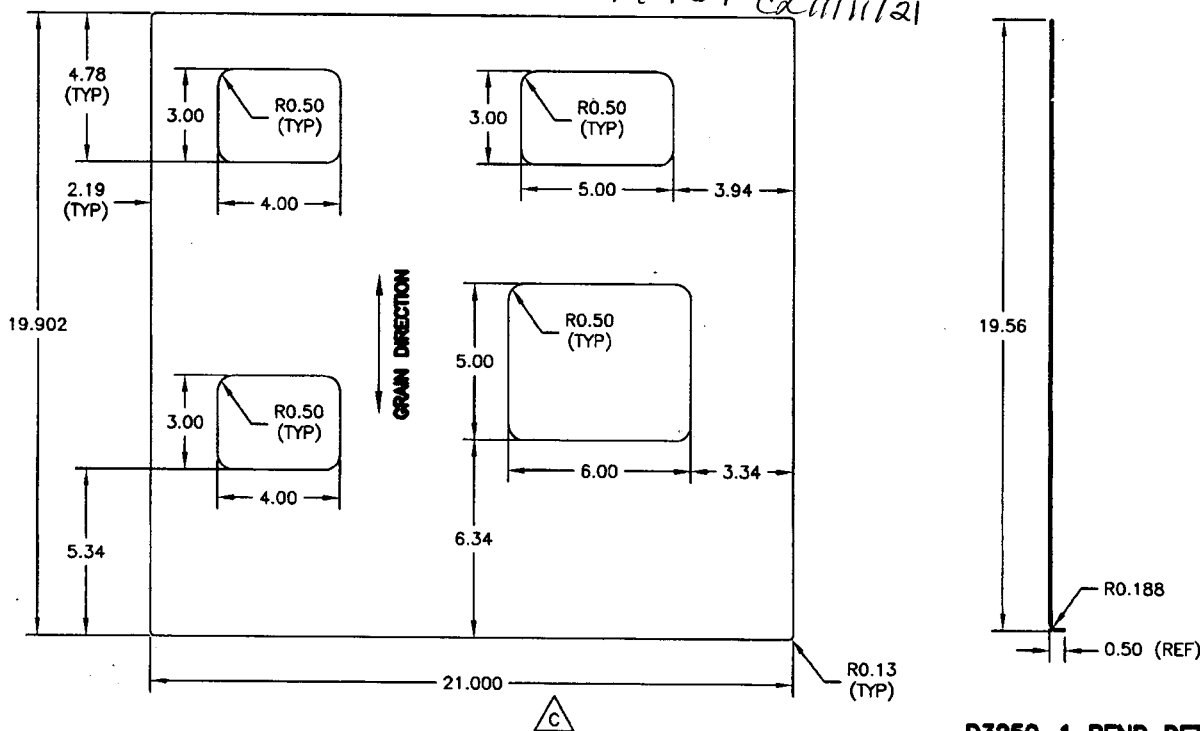
DESIGN RF	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3250	REV. C SHEET 1 OF 1
DATE 06.02.01		TITLE BACK (DUAL BATTERY RACK)	SCALE 1:6
A	04.04.06	NEW ISSUE	
B	04.11.04	20.625 WAS 20.243	
C	06.02.01	21.000 WAS 20.625, REMOVE Ø0.501 TOOLING HOLES	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. ~~76734~~ M.C.J.

RELEASED
06.02.13 H

76734 441115
02/11/21



D3250-1F FLAT PATTERN

D3250-1 BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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